

Push
Work Order ID 163485

Tuesday, June 27, 2017 1:22:00 PM

163485

Page 1

Item ID: D3295-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Replacement Interior Window for -111
Start Date: 6/27/2017 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 7/4/2017 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start *NR1*
QC: 3-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3295	E								

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.57

FLOW CNC Waterjet

ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING PARTS

1-Cut D3295-1 as per Dwg D3295

Dwg Rev: E

Prog Rev: E

2-Remove plastic, clean and wrap in saran wrap.

3-Deburr if necessary

(4)

06/17/07/02

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

(4)

06/17/07/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

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163485

Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				<u>4</u>			DAS 38 9-89 JUL 03 2017
130 *130* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3295. Put window in plastic wrap.	0.00 0.65				<u>4x</u>			DAS 36 9-89 17/07/10
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>4</u>			DAS 38 9-89 JUL 10 2017

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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 JUL 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐									

Picklist Print

Tuesday, June 27, 2017 1:22:03 PM

Page 1

Work Order ID: 163485

163485

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacement Interior Window for -111

Start Date: 6/27/2017

Required Date: 7/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-9034-01		Purchased				100	sf	53.5400	1.24	5.221053			

MI FXS 125-9034-01

1/8" 9034 Lexan Sheet (Clear)

**

06/17/07/03

Location

Loc Qty

Loc Code

MAT019

27.44

m135241

27.44

RM

26.1

m135485

26.1

D2728-1

Manufactured Yes

140

Each

2.0000

1

4

D2728-1

Dart Logo Label Small

**

17/07/11
DAS
36
9-89

Ø

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order:	163455
Description: Window		Part Number:	D3295
Inspection Dwg: D3295 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	Ø.159	1		Visual	
17.13	+/-0.030	17.13	1		Tap	
10.43	+/-0.030	10.43	1		Visual	
14.35	+/-0.030	14.35	1			
8.98	+/-0.030	8.98	1			
0.625	+/-0.010	.624	1			
7.109	+/-0.010	7.109	1			
15.845	+/-0.010	15.845	1			
2.308	+/-0.010	2.308	1			
5.420	+/-0.010	5.420	1			
9.402	+/-0.010	9.402	1			
1.312	+/-0.010	1.310	1			
6.260	+/-0.010	6.259	1			
12.520	+/-0.010	12.520	1			
0.313	+/-0.010	.316	1			
3.750	+/-0.010	3.750	1			
8.150	+/-0.010	8.150	1			
9.006	+/-0.010	9.006	1			
0.125	+/-0.010	.118	1			

Measured by:	<i>DE</i>	Audited by:	DAS 38 9-80	Preliminary Approval:	
Date:	17/07/02	Date:	JUL 03 2017	Date:	

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	<i>[Signature]</i>

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163485 MWS
1206-28

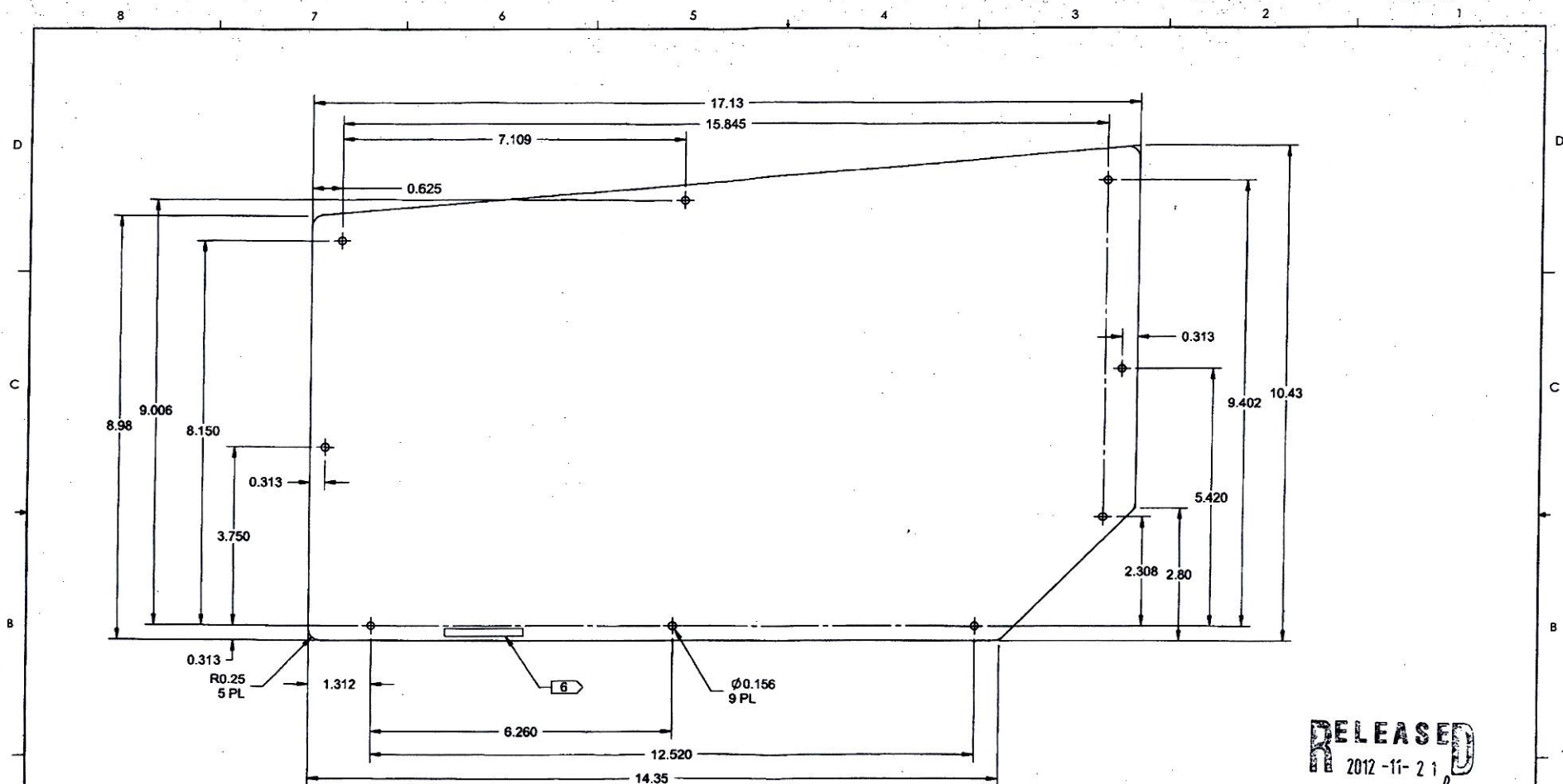
RELEASED
2012-11-21

D3295-041 FLOOR WINDOW

D3295-041B FLOOR WINDOW, BLANK

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) N/A
6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
7) WEIGHT: D3295-041/-041B = 0.87 lbs

REV.	DESCRIPTION	BY	DATE
E	ADD D3295-041B-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
DESIGN	43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3295 TITLE FLOOR WINDOW COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRESENTED AND CONSIDERED, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES, AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. E	SHEET 1 OF 3
DATE	12.11.15	SCALE	NTS



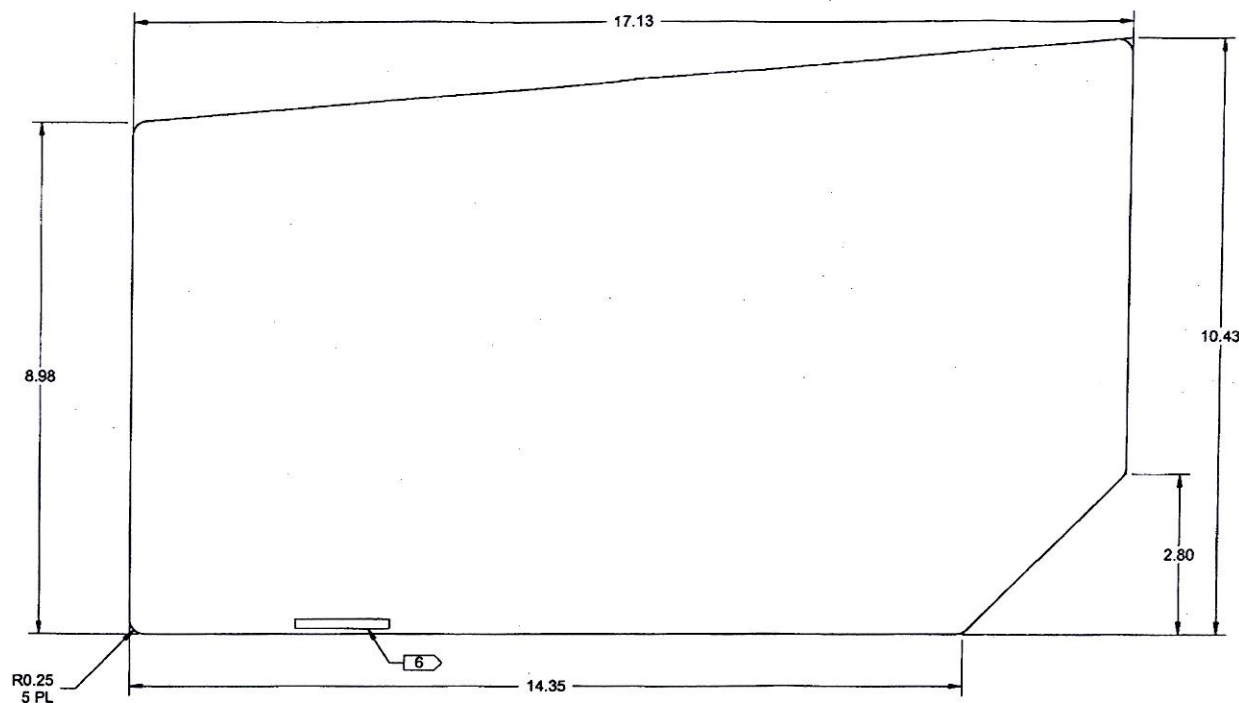
D3295-1 WINDOW

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3295	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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CHECKED	GP	DRAWING NO.	REV. E
MFG. APPR.	GP	D3295	SHEET 3 OF 3
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	FLOOR WINDOW	NTS
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